



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2574**Job Sheet 197162****Part No:** D2574**Job Qty:** 12 pcs**Part Name:** Saddle, Aft, In**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/2/19**Job Tracking No:****Due Date:** 7/26/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	12 pcs	7/26/19		0.00	0.00	HAAS - 1		SBL / VHS 19/7/24
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	12 pcs	7/26/19		1.00	19.35	HAAS - 1 - B4B		VHS 19/7/24
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	12 pcs	7/26/19		0.00	1.50	Conventional Mill - 1 - B4B		VHS 19/7/24
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	7/26/19		0.00	0.00	QC 2 - 1		VHS 19/7/24
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		

**Container No:** S199249**Part:** D2574**Job No:** 197162**Serial No/Batch:** S199249**Revision:** Rev.F**Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Date: 07/19/19

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				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	12 pcs	7/26/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
140	Handfinish - 1-1 Chemical- B4B	12 pcs	7/26/19	0.00 0.48	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B

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						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	12 pcs	7/26/19	0.00	0.39	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
160	QC 3	12 pcs	7/26/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	12 pcs	7/26/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	12 pcs	7/26/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-55

AUG 07 2019

Part Op **100** - (HAAS CNC vertical machine #1) Program Batch No. 5199241 Machine Step No 1 per Folio FA051 and inspect
 Descriptions: per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
110 - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 pcs (1 ea)	90-Machining - Issue SN	5196167 x 12

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-005	12	11	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Aft Inboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495	
4	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
5	Saddle, Aft Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990	
6	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
7	Saddle, Aft Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257	
8	Saddle, Aft Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375	
9	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
10	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174	

11	Saddle, Aft Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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DART AEROSPACE LTD	Work Order: 197162
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.499	.499	.498	.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.499	.500	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.135	.133	.135	.135		
Q	0.115	0.135		.123	.126	.126	.127		
R	0.240	0.260		.252	.253	.252	.253		
S	0.115	0.135		.135	.129	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.239	.241	.241		
W	0.115	0.135		.132	.130	.130	.130		
X	0.307	0.312		.311	.310	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.622	.622	.622		
AC	0.053	0.073		.062	.072	.072	.070		
AD	0.240	0.260		.253	.250	.251	.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.269	.265	.262	.269		
AH	0.240	0.260		.254	.252	.253	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject							DAS		

Measured by: SBC	Audited by: 20
Date: 19/07/21	Date: 19-07-29

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 191 162
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.7500	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.499	0.504	0.498	
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.499	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.174		
K	0.558	0.578		0.567	0.567	0.566	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.253	0.252	0.252	0.252		
S	0.115	0.135		0.128	0.127	0.128	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.241	0.241	0.241		
W	0.115	0.135		0.129	0.130	0.129	0.130		
X	0.307	0.312		0.311	0.311	0.311	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.622		
AC	0.053	0.073		0.067	0.067	0.067	0.067		
AD	0.240	0.260		0.252	0.252	0.252	0.252		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.264	0.260		
AH	0.240	0.260		0.252	0.252	0.254	0.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: SBL	19/07/21
Date: 19/07/21	19/07/21

Audited by: DAS	20
Date: 19-07-29	9:55

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 191 162
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.499	0.500	0.501	0.501		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.498	0.501	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.565	0.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.126	0.126	0.126		
R	0.240	0.260		0.250	0.252	0.253	0.253		
S	0.115	0.135		0.128	0.128	0.128	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.232	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.239	0.240	0.240		
W	0.115	0.135		0.129	0.130	0.130	0.130		
X	0.307	0.312		0.310	0.310	0.310	0.3105		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.363	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.623	0.624		
AC	0.053	0.073		0.068	0.068	0.068	0.066		
AD	0.240	0.260		0.251	0.2505	0.250	0.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.255	0.255	0.255	0.255		
AH	0.240	0.260		0.245	0.245	0.245	0.243		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

DAS

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 19/7/23	Date: 19-07-29

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 19/7/23	Date: 19-07-29

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	